

Split

Wednesday 27/08/2008 3:15:28 PM
Julie Lepocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 41647 - *3*
Estimate Number : 12568
P.O. Number :
This Issue : 27/08/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 27/08/2008 Type : LARGE FAB ASSY
Previous Run : 41244

Drawing Name : HELI-ACCESS STEP RH (FOLDING)
Part Number : D412630034
Drawing Number : IIN D412-630
Project Number : N/A
Drawing Revision : L
Material :
Due Date : 10/09/2008 Qty: *4* Um: Each

Written By :
Checked & Approved By : *JDC 83 26*
Comment : Est. Rev:A New Issue 06-11-08 JLM
est rev B ecn1019, added D2807-041 EC verified by:DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :
1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Photocopy bluefile & create labels per PPP D412-630-034 CHG003

2.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Clevis

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	<i>1074</i>

338773 *EP 09/02/18*

SS 01/01/12 (4)

3.0 D2803042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-042	Bracket Assembly RH	<i>4167312</i> <i>3401712</i>

4167312
3401712

SS 01/01/12 (4)

4.0 D2804042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2804-042	Bracket Assembly RH	<i>44492</i>

44492

EP 09/01/13

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services






Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 41647

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	D2807041	Door prop
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Support Prop Batch: <u>35751</u> <i>SS 09/01/12 (x4)</i>		
6.0	D2813	Washer
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Washer Pick: Qty Part Number Description Batch 2 D2813 Washer <u>41667 x4</u> <u>34020 x4</u> <i>SS 09/01/12 (x4)</i>		
7.0	D3562042	Step Assembly, RH
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Step Weldment LH Pick: Qty Part Number Description Batch 1 D3562-042 Step Weldment RH <u>B44065</u> <u>B44039</u> <i>SS 09/01/12 (x4)</i>		
8.0	D33951	Bushing
		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) Bushing Pick: Qty Part Number Description Batch 4 D3395-1 Bushing <u>41669</u> <i>SS 09/01/12 (x4)</i>		
9.0	AN3C21A	BOLT
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) BOLT Pick: Qty Part Number Description Batch 2 AN3C21A Bolt <u>M61189</u> <i>SS 09/01/12 (x4)</i>		

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 41647

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
15.0	NAS1515H8	Washer
Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) Washer Pick: Qty Part Number Description Batch 4 NAS1515H8 Washer M109099 SS 09/01/12 (4)		
16.0	MS210433	Nut
Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) Nut Pick: Qty Part Number Description Batch 4 MS21043-3 Nut M110023 x11 M109535 x5 SS 09/01/12 (4)		
17.0	MS24693C280	Screw
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Screw Pick: Qty Part Number Description Batch 2 MS24693-C280 Screw (or MS24694-C565) M101390 SS 09/01/12 (4)		
18.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per dwg D412-630 p.14 Coat all hardware with LPS3 rust inhibitor A/R LPS3 batch: M109929 COAT exposed HARDWARE WITH LPS PROCYON . A/R LPS PROCYON BATCH: M104251 EF 09/02/18 (4)		
19.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP SS 09/02/18 (1)		

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 41647

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation: Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : ²8.0000 Each(s)
Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-1

Bushing

42174

SS 09/02/17 (X)

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : ²8.0000 Each(s)
Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-3

Bushing

42175

SS 09/02/17 (X)

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : ²4.0000 Each(s)
Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2810-5

Strut

41676

SS 09/02/17 (X)

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : ²8.0000 Each(s)
Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3396-1

Spacer

41670

SS 09/02/17 (X)

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : ²4.0000 Each(s)
Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

M109147

SS 09/02/17 (X)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 41647

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1	AN4C6A	Bolt	
26.0	AN4C10A	Bolt	
Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)			
Bolt			
Pick: Packing Kit			
Qty	Part Number	Description Batch	
1	AN4C10A	Bolt	M104679
27.0	AN4C15A	Bolt	
Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)			
Bolt			
Pick: Packing Kit			
Qty	Part Number	Description Batch	
2	AN4C15A	Bolt	M107082
28.0	AN44C7A	Eyebolt	
Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)			
Eyebolt			
Pick: Packing Kit			
Qty	Part Number	Description Batch	
1	AN44-C7A	Eyebolt	M100446
29.0	AN5C15A	Bolt	
Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)			
Bolt			
Pick: Packing Kit			
Qty	Part Number	Description Batch	
2	AN5C15A	Bolt	M105125
30.0	NAS1515H4	Washer	
Comment: Qty.: 7.0000 Each(s)/Unit Total: 28.0000 Each(s)			
Washer			
Pick: Packing Kit			
Qty	Part Number	Description Batch	
7	NAS1515H4	Washer	M109267

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 41647

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

31.0	NAS1515H5	Washer
------	-----------	--------



Comment: Qty.: 7.0000 Each(s)/Unit Total : ⁷28.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H5	Washer	M109430

SS 09/02/17 (X)

32.0	MS210434	Nut
------	----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : ⁴16.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	MS21043-4	Nut	M110023

SS 09/02/17 (X)

33.0	MS210435	Nut
------	----------	-----



Comment: Qty.: 3.0000 Each(s)/Unit Total : ⁴12.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
3	MS21043-5	Nut	M110123

SS 09/02/17 (X)

34.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

09.02.20 (1)

35.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location: _____

PPP Rev: _____

04/3/10 (1)

36.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



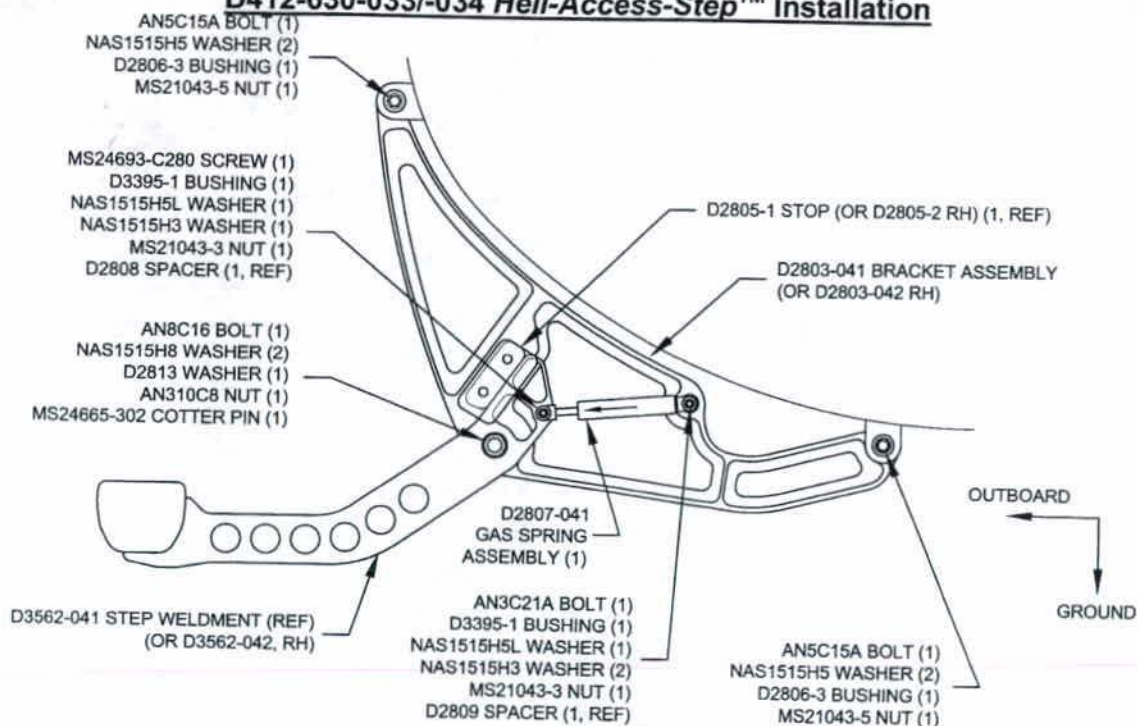
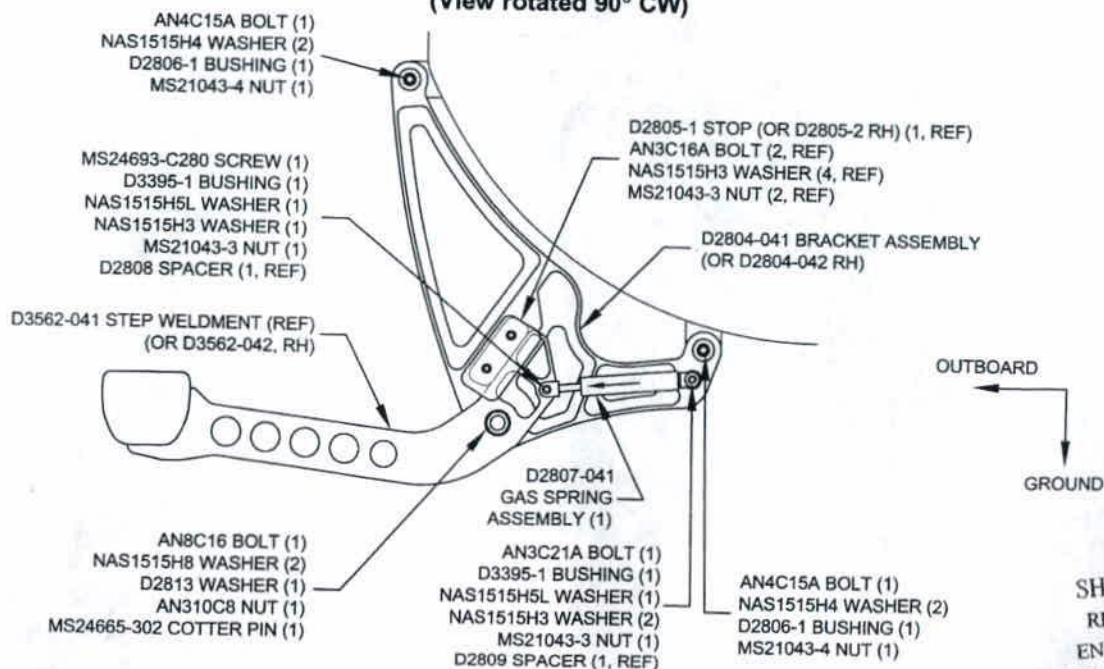
Comment: FINAL INSPECTION/W/O RELEASE

09/03/10 (1)

Job Completion



mk 09-03-10

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation (View rotated 90° CW)****FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation (View rotated 90° CW)**

• COPYRIGHT © 1996 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **L**
Date: 07.09.30

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 9164